

Work Order ID 72660

Thursday, August 04, 2011 8:16:12 AM



Page 1

Item ID: DSK078

Accept



Setup Start



Revision ID:

Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 8/4/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *X* Date: 11-08-11 Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSK078	Rev A								

100

0.00



MORI SEIKI CNC LATHE LARGE

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA081
(4TH AXIS PLUG DT8492)

RR 11.8.11

10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

RR 11.8.11

10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

and 11/08/12

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00				10	0		
Packaging	Identify and Stock in Kanban Location: <u>MAH</u>								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

anh 11/08/12

11/8/15

YMF 11-08-11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, August 04, 2011 8:16:19 AM

Page 1

Work Order ID: 72660

Parent Item: DSK078

Parent Item Name: D2893-1 TURNING DETAIL

Start Date: 8/4/2011

Required Date: 8/5/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-005		Manufactured	No				Each	24.0000		10			
-----------	--	--------------	----	--	--	--	------	---------	--	----	--	--	--



Round Billet, 17-4



22 11-8-11

Location

Loc Qty

Loc Code

MAT

12

70254

12

MAT047

12

71179 ✓

12

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DART AEROSPACE LTD		Work Order:	72600
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712	RP .02	2.709	2.709	2.709	2.709	2.709
B	4.946	4.966	RP .12	4.956	4.956	4.956	4.956	4.956
C	3.064	3.084		3.078	3.078	3.078	3.078	3.078
D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.103	.103	.103	.103	.103
F	2.934	2.954		2.945	2.945	2.945	2.945	2.945
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.903	3.903	3.903	3.903	3.903
I	0.914	0.934		.924	.924	.924	.924	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.115	.115	.115	.115	.115
L								
M								
N								
O								
P								

Measured by: RP Date: 11. 8. 12

Audited by: ONL Date: 11/ 08/12

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

2.709	2.709	2.709	2.709	2.709
4.956	4.956	4.956	4.956	4.956
3.078	3.078	3.078	3.078	3.078
.728	.728	.728	.728	.728
.103	.103	.103	.103	.103
2.945	2.945	2.945	2.945	2.945
2.176	2.176	2.176	2.176	2.176
3.903	3.903	3.903	3.903	3.903
.924	.924	.924	.924	.924
.032	.032	.032	.032	.032
.115	.115	.115	.115	.115
6	7	8	9	10

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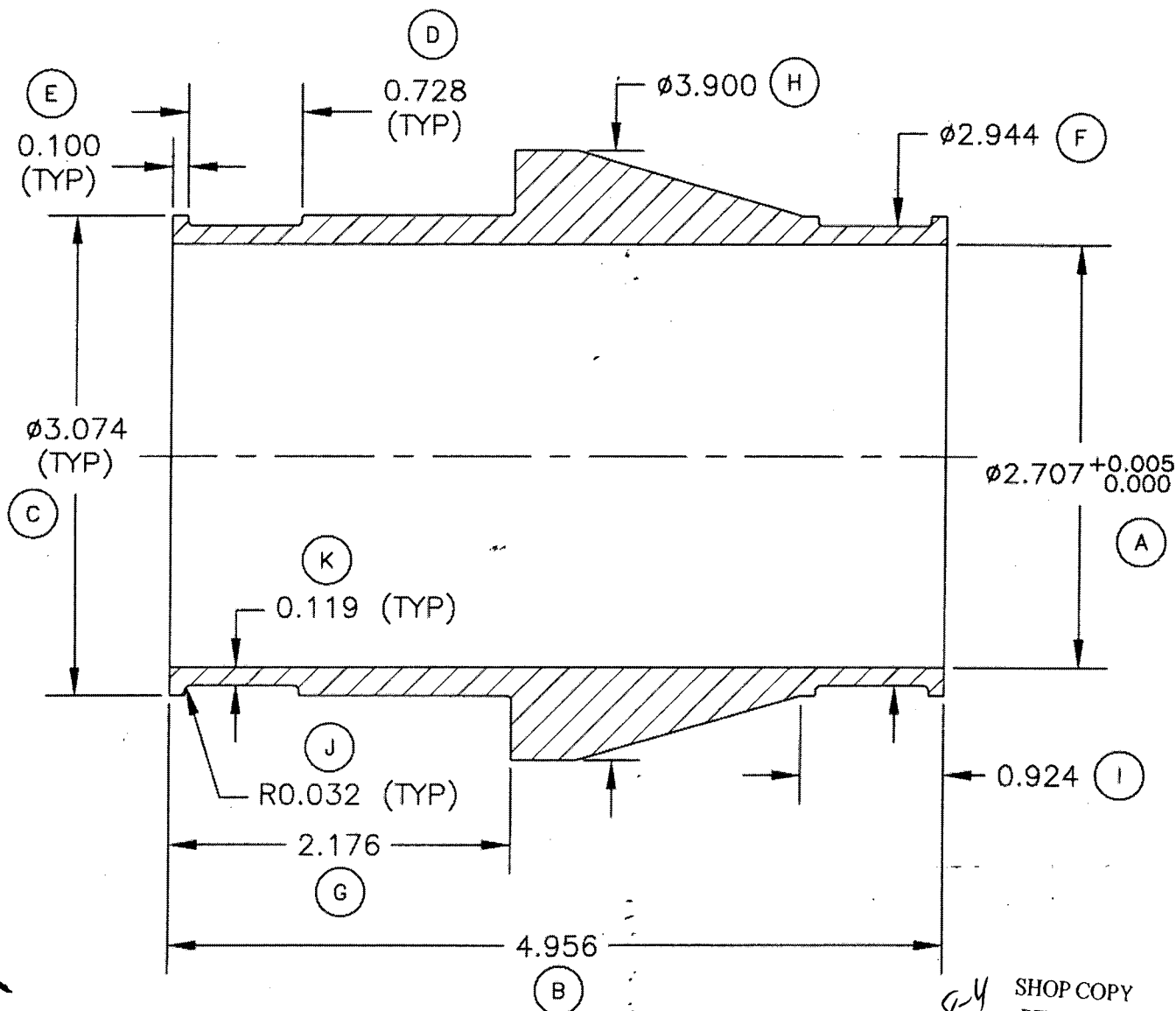
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DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



D2893-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72660

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